



Piping Frequently Asked Questions

1. What are the inspection requirements for installation of welded steel piping for refrigeration systems?

Answer: For any system installed, modified or repaired using welded steel piping, a contractor must complete a SBD-5204 registration form, [PDF file](#), and arrange an inspection at least five business days prior to the start of fabrication (all welded steel piping shall be fabricated to ANSI B31.5, 2001 std. pipe welders need welder qualifications per piping code ASME B31.5 and ASME Section IX.) and in accordance with SPS 345.07 and 345.08. An Industry Services [Refrigeration Systems Gas and Anhydrous Ammonia map](#) is online.

2. What is required if two solenoid valves are added to a refrigeration system? The equivalent length of pipe involved is under 20 feet and a max of 1-1/4 inch.

Answer: Assuming the piping and solenoid valves are new and welded, SPS 345.08 requires inspection.

SPS 345.02 Scope. (1) APPLICATION. This chapter applies to all of the following: (a) The installation of mechanical refrigerating systems and heat pumps. (b) A change to a refrigerant of a different number designation. (c) Parts or components replaced only if they are not identical in function. (d) Additions or alterations to any refrigerating system that exceeds the registration criteria in SPS 345.07.

SPS 345.08(2)(b) The department shall inspect refrigerant steel piping using welded joints to be erected on the premises after the piping material is delivered to the job site and prior to the start of construction. The installer shall give the department a minimum of five business days notice to arrange for the inspection.

SPS 345.08(2)(c) The installer shall complete form SBD-5204 and retain it at the job site prior to the refrigerant piping inspection. The certified inspector shall indicate acceptance of the refrigerant piping system design by signing form SBD-5204.